



Dart Aerospace Ltd.
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D3560-3**Job Sheet 189814****Part No:** D3560-3**Job Qty:** 4 pcs**Part Name:** Arm**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/30/19**Job Tracking No:****Due Date:** 2/8/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV D IPP Rev:A New Issue 06-11-10 JLM use-043 IPP REV:B 13.06.03 PER DWG REV:F DD
VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	2/8/19	2/8/19	0.00	0.00	Bandsaw - 1		SBL 19/02/02
110	HAAS 4 Axis - B4B	4 pcs	2/8/19	2/8/19	0.49	2.99	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/02/03
							HAAS - 4 - B4B		
120	QC 2	4 pcs	2/8/19	2/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



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Container No: S150325**Part:** D3560-3**Job No:** 189814**Serial No/Batch:** S150325**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/02/19

				QC 2 - 56	
				QC 2 - 57	SBL 19/02/03
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
124	Conventional Mill - 1 - B4B	4 pcs	2/8/19	0.00 0.35	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
126	QC 2	4 pcs	2/8/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
130	QC 8	4 pcs	2/8/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
210	Packaging 3-1 - Stock - B4B	4 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B

					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	SLU
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
220 QC 21 - SA	4 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21		DAS
				QC 21 - SA - 70		21 FEB 05 2019 9-51

Part Op **100** - Cut blanks 15.500" long
 Descriptions: **110** - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA695 Rev: _____ & Dwg D3560 Rev: _____
120 - (QC2- Inspect parts off machine FAI/FAIB)
124 - (Manufacture as per dwg)
126 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
210 - (Identify as per dwg & Stock Location: _____), LOCATION: WA003
220 - (QC21- Final Inspection - Work Order Release), 2-Deburr per dwg D3560

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	5.5600 ft (1.39 ea)	100-Bandsaw - 1	5036667

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X05.000	6	27	0

MAT
used.
5.19'

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.507Inches + 0.000 - 0.001	0.507 0.506	Diameter	,506
2	Arm	0.196Inches + 0.005 - 0.001	0.201 0.195	Diameter	,196
3	Arm	1.000Inches + 0.010 - 0.001	1.010 0.999	Diameter	,005
4	Arm	0.900Inches + 0.010 - 0.001	0.910 0.899	Diameter	,902
5	Arm	0.500Inches ± 0.010	0.510 0.490		,498
6	Arm	0.250Inches ± 0.010	0.260 0.240		,249
7	Arm	0.275Inches ± 0.010	0.285 0.265		,275
8	Arm	0.188Inches ± 0.010	0.198 0.178		,188
9	Arm	1.750Inches ± 0.010	1.760 1.740		,747
10	Arm	1.702Inches ± 0.010	1.712 1.692		,707
11	Arm	0.385Inches ± 0.010	0.395 0.375	Diameter	0,385 //
12	Arm	100.000Degrees ± 0.500	100.500 99.500	Angle	100° //
13	Arm	0.250Inches ± 0.010	0.260 0.240	Depth	,248

Plex 1/30/19 2:52 PM Dart.lajeunesse.marie

DAS
57
9-89

19/02/03

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					